



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

ASAP

647.2510

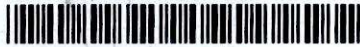
Job Sheet 211953



Part No: 647.2510

Job Qty: 36 pcs

Part Name: Sleeve



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/31/20

Job Tracking No:

Due Date: 8/14/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 647.2500 REV.A IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED BY:DD IPP REV:B 19.02.27 AS PER
DWG REV.A DD VERF:JFS

Ship Via:

PRIORITY

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	36 pcs		8/13/20	1.00	12.00	Doosan - 1		
110	QC 2	36 pcs		8/13/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Container No: S295542



Part: 647.2510
Job No: 211953
Serial No/Batch: S295542
Revision: Rev A
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/21/20



Container No: S295542

Part: 647.2510

Job No: 211953

Serial No/Batch: S295542

Revision: Rev A

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 08/21/20

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						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 2 - 76	
						QC 2 - 86	
						QC 2 - 83	
112	Conventional Lathe - 1 - B4B	36 pcs	8/14/20	0.00	3.00	Conventional Lathe - 1 - B4B	
						Conventional Lathe - 2 - B4B	
115	QC 2	36 pcs	8/14/20	0.00	0.00	QC 2 - 1	
						QC 2 - 12	
						QC 2 - 14	
						QC 2 - 17	
						QC 2 - 19	
						QC 2 - 2	
						QC 2 - 20	
						QC 2 - 22	
						QC 2 - 23	
						QC 2 - 25	
						QC 2 - 32	
						QC 2 - 33	
						QC 2 - 35	
						QC 2 - 39	
						QC 2 - 4	
						QC 2 - 40	
						QC 2 - 44	
						QC 2 - 45	
						QC 2 - 48	
						QC 2 - 49	
						QC 2 - 50	
						QC 2 - 51	
						QC 2 - 52	
						QC 2 - 57	
						QC 2 - 62	
						QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 2 - 76	
						QC 2 - 86	
						QC 2 - 83	
140	QC 8	36 pcs	8/14/20	0.00	0.00	QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	3.C.-L. 20-08-23
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	

Not required
(was done at previous)
operation

B.E

					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
150	Outsource - 17 - Passivate	36 pcs	8/14/20		GRO002-VC	<i>HL 2020-08-25</i>
160	Packaging 2-1 - Receive - B4B	36 pcs	8/14/20	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	<i>HL</i> AUG 3 1 2020
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	

170 QC 6	36 pcs	8/14/20	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	DAS
				QC 6 - 81	82
				QC 6 - 82	9-89
					AUG 31 2020
180 Packaging 3-1 - Stock - B4B	36 pcs	8/14/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	DAS
				Packaging 3 - 3 - B4B ✓	SEP 01 2020 80
				Packaging 3 - 4 - B4B	9-89
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
190 QC 21 - SA	36 pcs	8/14/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	SEP 01 2020 DAS
				QC 21 - SA - 9	70
				QC 21 - SA - 77	9-89

Part Op 100 - 1- Turn as per Folio FB144 AND DWG DWG Rev: A FOLIO Rev: AA -Deburr per dwg ***CHECK THREADS
 Descriptions: USING GO/ NO GO GAUGE*****

110 - (QC2- Inspect parts off machine FAI/FAIB) QC2- Inspect parts off machine FAI/FAIB

112 - REAM .250/.252" HOLE AS PER DWG.

115 - (QC2- Inspect parts off machine FAI/FAIB) QC2- Inspect parts off machine FAI/FAIB

140 - 100% CHECK, CHECK ALL DIMENSIONS AND THREAD FIT

150 - Issue P/O: 46951 Pasivate as per MIL-S-5002 TYPE 6 Certificate of conformaty is required

160 - (Receive & Inspect for Damage & Mat'l Certs) Receive & Inspect for Damage & Mat'l Certs

170 - QC6- All purchased or subcontracted products

180 - Identify as per dwg & Stock Location: _____

190 - (QC21- Final Inspection - Work Order Release) QC21- Final Inspection - Work Order Release

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R1.000	17-4 SS Round Bar 1.000"	11.9988 ft (.3333 ea)	100-Doosan - 1	S295073
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M17-4-H1150-R1.000	12	1	0
Part Specifications				
Specifications could not be found.				

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SC .1262

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

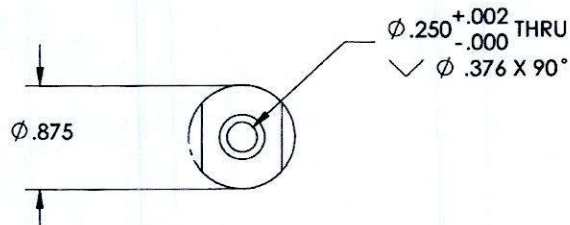
NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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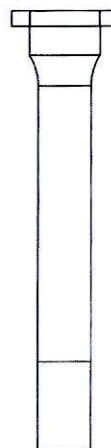
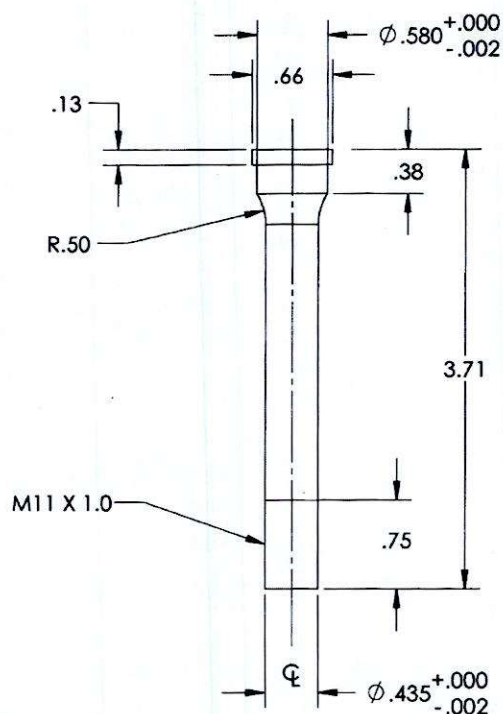
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PROTOTYPE REVISION: P01		
2	INITIAL RELEASE	06/04/09	P. BRAVO
3	INCORPORATED ECH 020935. 04227	11/11/13	P. BRAVO



647.2510

NOTES:

- 1 MATERIAL: STAINLESS STEEL 17-4 PH, CONDITION: H1150
- 2 FINISH: PASSIVATE PER MIL-S-5002 TYPE 6
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120



QTY	647.2511	NUT			
	647.2510	SLEEVE			
	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
PARTS LIST					
APICAL INDUSTRIES					
2608 TEMPLE HEIGHTS DR.					
OCEANSIDE, CA. 92056-3512 (760)724-5300					
SKID SLEEVE					
ORIGINAL DATE	06-04-09	REV			
DRAWN BY	1. GARDNER	CHECKER			
DRAWING APPROVAL	P. BRAVO				
CONTRACT NO.					
UNLESS OTHERWISE SPECIFIED					
DIMENSIONS ARE IN INCHES					
TOLERANCES ARE:					
2 PLACE DECIMALS ±.01					
3 PLACE DECIMALS ±.005					
ANGLES ±.5°					
SCALE	NONE				
SHEET	1 OF 2				



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046954



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046954

PO Date: 8/25/20

Due Date: 9/2/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	212077	650.9610	650.9600 REV-PB2	Electric Valve Body -Issue P/O; _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed	-	9/2/20	6 pcs	0 pcs	6 pcs	\$0.35/pcs	\$2.10
					X6					AUG 31 2020		
2	210876	651.0101	651.0100 REV.PE2	Angled Gauge Adapter -Issue P/O; _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 316 stainless steel -Certificate of Conformity is required	Firmed	-	9/2/20	3 pcs	0 pcs	3 pcs	\$0.35/pcs	\$1.05
					X3					AUG 31 2020		
3	210662	650.7712	650.7700 REV.PF1	Mechanical Cap -Issue P/O; _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed	-	9/2/20	3 pcs	0 pcs	3 pcs	\$0.35/pcs	\$1.05
					X3					AUG 31 2020		
4	211175	650.7810	650.7800 REV.PA1	Pull Rod -Issue P/O; _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed	-	9/2/20	3 pcs	0 pcs	3 pcs	\$0.35/pcs	\$1.05
					X3					AUG 31 2020		



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PURCHASE ORDER

POHB046954



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	212002	654.6411	654.6400 REV-PR2	Plug Fitting -Issue P/O; _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed XS	-	9/2/20	5 pcs	0 pcs	5 pcs	\$0.35/pcs	\$1.75
6	212001	654.6412	654.6400 REV-PR2	Fill Piston Fitting -Issue P/O; _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed XS	-	9/2/20	5 pcs	0 pcs	5 pcs	\$0.35/pcs	\$1.75
7	211954	647.2511	647.2500 Rev A	Nut : Various STC's Issue P/O: _____ Pasivate as per MIL-S-5002 TYPE 6 Certificate of conformaty is required	Firmed X36	-	9/2/20	36 pcs	0 pcs	36 pcs	\$2.45/pcs	\$88.20
8	211953	647.2510	647.2500 Rev A	Sleeve : Various STC's Issue P/O: _____ Pasivate as per MIL-S-5002 TYPE 6 Certificate of conformaty is required	Firmed X36	-	9/2/20	36 pcs	0 pcs	36 pcs	\$0.88/pcs	\$31.68
Grand Total:												\$128.63

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

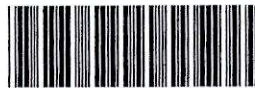
A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/28/20 4:16 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance



030554-1

Bon de Livraison / Packing Slip

030554-1

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
28-Aug-2020		Ian Wilson		POHB046954					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	A venir/ Back Order	
1	650.9610 Rev.	650.9610 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST PASSIVATE IAW QQ-P-35C MATERIAL TYPE: 303 STAINLESS STEEL	PASSIVATION CH	6	6	0	0	0	
2	651.0101 Rev.	651.0101 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST PASSIVATE IAW QQ-P-35C, TYPE II MATERIAL TYPE: 316 STAINLESS STEEL	PASSIVATION CH	3	3	0	0	0	
3	650.7712 Rev.	650.7712 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] PASSIVATE IAW QQ-P-35C, TYPE II MATERIAL TYPE: 303 STAINLESS STEEL	PASSIVATION CH	3	3	0	0	0	
4	650.7810 Rev.	650.7810 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] PASSIVATE IAW QQ-P-35C, TYPE II MATERIAL TYPE: 303 STAINLESS STEEL	PASSIVATION CH	3	3	0	0	0	
5	654.6411 Rev.	654.6411 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] PASSIVATE IAW QQ-P-35C, TYPE II MATERIAL TYPE: 303 STAINLESS STEEL	PASSIVATION CH	5	5	0	0	0	
6	654.6412 Rev.	654.6412 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] PASSIVATE IAW QC-P35C, TYPE II MATERIAL TYPE 303 STAINLESS STEEL	PASSIVATION CH	5	5	0	0	0	
7	647.2511 Rev.	647.2511 01 -PASSIVATION DICHROMATE [PASSIVATION DICHROMATE] PASSIVATE AS PER MIL-S-5002 TYPE 6	PASSIVATION CH	36	36	0	0	0	
8	647.2510 Rev.	647.2510 01 -PASSIVATION DICHROMATE [PASSIVATION DICHROMATE] PASSIVATE AS PER MIL-S-5002 TYPE 6	PASSIVATION CH	36	36	0	0	0	

DAS
82
9-89

RECEIVED

AUG 28 2020

DART AEROSPACE LTD.

030554-1

030554 - 1

1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

DART AEROSPACE LTD.

Page 2 of 2